

Work Order ID 62078

September 15, 2010 3:15:58 PM



Page 1

Item ID:	D2519	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Clamp					
Start Date:	9/15/10	Start Qty:	50.00		Cust Item ID:	
Required Date:	9/24/10	Req'd Qty:	50.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>10/9/16</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2519	Rev D

100		0.00							
	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>12574</u> <input type="checkbox"/> Laser cut as per Dwg D2519 <input type="checkbox"/> Material release note required								<u>CZ 10/9/16 (50)</u>
110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								<u>10/9/30 (50)</u>
120		0.00							
	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control	(8.561" center to center)								<u>counted (50)</u>

8/10/10/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62078

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Item ID: D2519

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 9/15/10

Start Qty: 50.00



Cust Item ID:

Required Date: 9/24/10

Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

1-Deburr any rough edges ☐ 2-Bend as per Dwg D2519 ☐ 3- tumble

u/as

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

u/as

Quality Control

150

0.00



Identify as per dwg & Stock Location: 462

Packaging

Memo

0.00

u/as

500

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62078

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Item ID: D2519

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 9/15/10

Start Qty: 50.00



Cust Item ID:

Required Date: 9/24/10

Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/04 *[Signature]*
MP
10-10-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 62078



Parent Item: D2519



Parent Item Name: Clamp

Start Date: 9/15/10

Required Date: 9/24/10

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B□00.03.16□Re-format, laser cutting□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2519F

Purchased

No

120

Each

0.0000

1

50



Clamp

CL 10/9/30 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

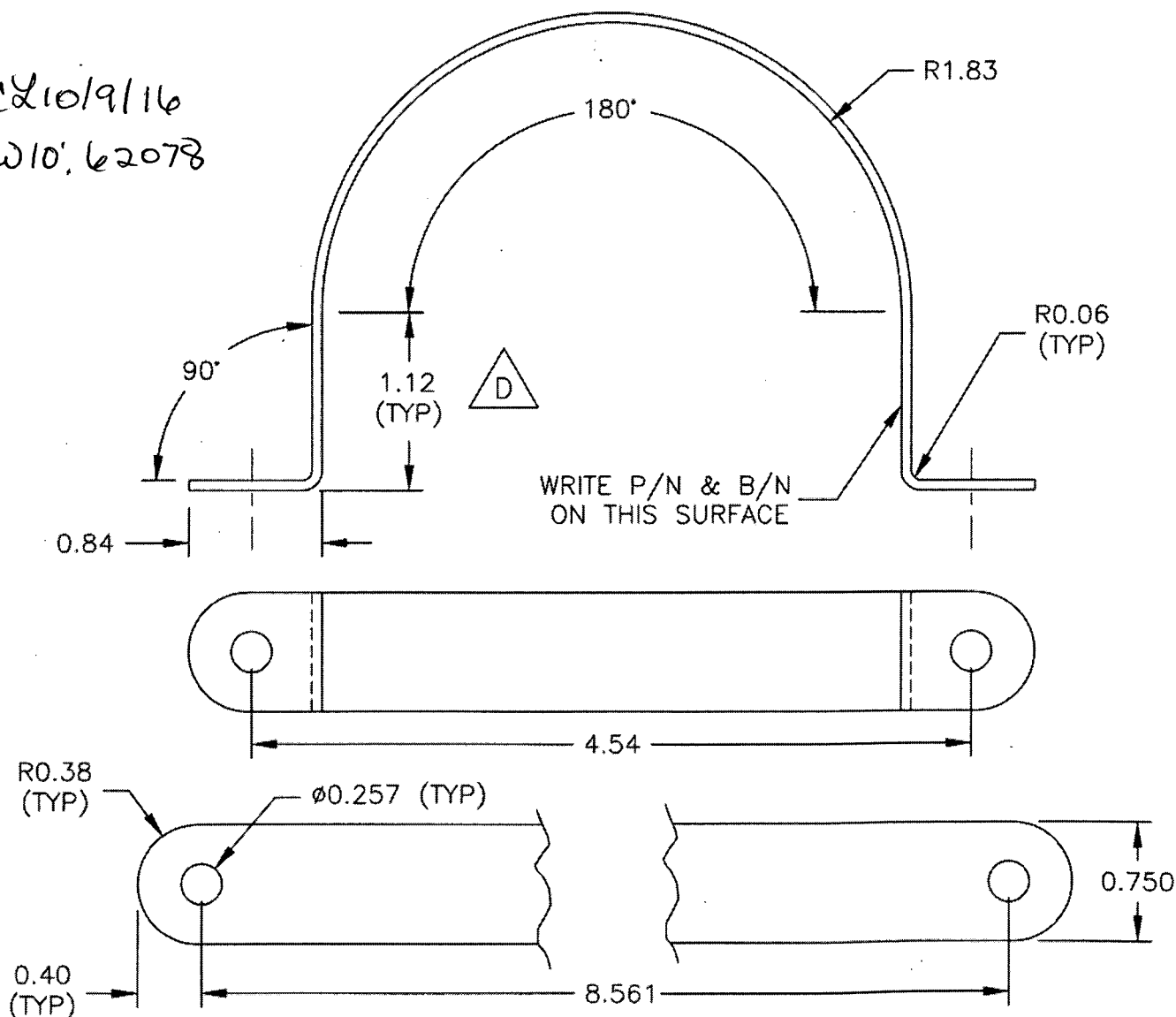
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2519	REV. D SHEET 1 OF 1
DATE 04.11.08		TITLE CLAMP	SCALE 1:1
A	95.11.28	NEW ISSUE	
B	97.03.24	ADD MATERIAL SPECIFICATION	
C	00.02.29	REDRAWN; ADDED FLAT PATTERN	
D	04.11.08	1.12 WAS 0.93	

RELEASED
04.11.26 *[Signature]*

C210/9/116
W10.62078



D2519 FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK, (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSION ARE IN INCHES
- 4) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER ON SURFACE SHOWN

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: AISI 304/316 SS SHEET
ANNEALED
2B FINISH

SPECIFICATION: MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240

PART NUMBER: M304S TT GA
GA

WHERE "TT" = GAUGE THICKNESS

EG. 16 GAUGE SS SHEET = M304S16GA

GAUGE THICKNESS REFERENCE:

GAUGE	NOM. THICK. (IN)	THICKNESS RANGE (IN)
26	0.01875	0.0178 - 0.019
25	0.021875	0.0199 - 0.023
24	0.025	0.024 - 0.026
23	0.028125	0.027 - 0.029
22	0.03125	0.030 - 0.032
21	0.034375	0.033 - 0.035
20	0.0375	0.036 - 0.040
19	0.04375	0.041 - 0.046
18	0.050	0.047 - 0.052
17	0.05625	0.053 - 0.058
16	0.0625	0.059 - 0.065
15	0.0703125	0.066 - 0.072
14	0.078125	0.073 - 0.083
13	0.09375	0.084 - 0.098
12	0.109375	0.099 - 0.114
11	0.125	0.115 - 0.130
10	0.140625	0.131 - 0.145
9	0.15625	0.146 - 0.160
8	0.171875	0.161 - 0.176

REFERENCE ONLY

62078
RELEASED
09/06/01

B	REFORMAT DWG, ADD ASTM/ASME SPECS (ZN D8-1), ADD GAUGE REF (C8-1), REF PAR 08-020A	CP	09.06.01
A	NEW ISSUE	DS	01.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. M304S	REV. B SHEET 1 OF 1
TITLE 304/316 SS SHEET	SCALE NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO12574

Purchase Order Date 9/16/10

PO Print Date 9/16/10

Page Number 1 of 1

Order From :

VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

Contact Name

Vendor Phone 514 630 4877

Vendor Fax 514 630 4849

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
(9/10/10)
e-mail

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2519F	Clamp	9/30/10 Yes	50.00 Each	Purolator ground	\$7.7500	\$387.50

Special Inst: AS PER DWG D2519 REV. D
B62078

PO Total:

\$387.50

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 9/16/10

CL
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO	PAGE
JR - DY	MO - MO	AN - YR		
28	09	10	0446772	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR / SHIP VIA
DART	GFI-0299	0220394	P012574

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO	DESCRIPTION
---------------------	-----------------------	-------------

50 D2519F

CLAMP

CERTIFICATE OF CONFORMANCE REQ

S10161ay

MFG. JOB# J0220394-001 QTY 50

DA



EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

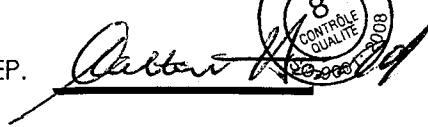
CERTIFICATE NO. 8 OUR JOB NO J0220394 SHIPPING MEMO 0446772

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	<u>50 PCS</u>	<u>PO12574</u>	<u>D2519F</u>	<u>D</u>	<u>CLAMP</u>	<u>D</u>
MATERIAL <u>S.S.T 304</u>		SUPPLIED BY <u>SAMUEL & THYSSENKRUPP</u>			MAT. REL. NO. <u>854412 ATT'D</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	REF. GFI MANUFACTURING JOB NUMBER J0220394-001 (50 PCS)		
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 29 AUGUST 2010

G.F.I. Q.C. REP. 





SAMUEL & FILS & CIE (QUEBEC) LTEE.,
2225 AVE. FRANCIS HUGHES,
CHOMEDEY, LAVAL
QUEBEC, H7S 1N5
(514) 384-5220 FAX (450) 669-0633

No 001745245



PAGE 2 DE/OF 3

TRANSPORTEUR/CARRIER NAME ACTEURS - SAMUEL	CAMION/TRUCK 304	NOM DE LA BRANCHE/SALES BRANCH NAME SAMUEL & FILS & CIE (QUEBEC) L	DATE/EXP. DATE OF SHIPMENT 8/11/10
---	---------------------	---	---------------------------------------

VENDU À/SOLD TO:
GFI, DIVISION DE THOMAS & BETTS LTEE
180 LABROSSE

POINTE-CLAIRE
QC
H9R1A1 (514) 630-4877

EXPÉDIÉ À/SHIP TO: TÀB: DEST
GFI INC.
180 LABROSSE

POINTE-CLAIRE
QC
H9R1A1 CA (201009-00001)

N° COMMANDE
N° ITEM
299406-02

DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: CC05602 Cert/Test: FAX
8333 LBS FEUILLE INOXYDABLE 304 2B 7795 LVR

.0620"x48"x96"
c of c & Mill test Req.

#Pièce Ts06248x9642

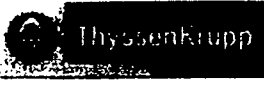

Description #Étiq mln	Art #À soul	Pd ca	Qté	#Étiq Étiq princ	Vendeur Org #Coul
	35	1120.000	2675	5431113	076 DE
5166172				1213 KG	
	32	1024.000	2445	P218111 5431127	854412 076 DE
				1109 KG	
5166172				P218111 5431130	854412 076 DE
	35	1120.000	2675	1213 KG	
5166172				P218111	854412
Total:	102	3264.000	7795	3535 KG	

8/10/10

DATE 8/12/10
DEPT. DE
CERTIFICATION Louise Stier

PAÏÉ PAR CHARGES	PORT PAYÉ/PREPAID	PORT DÙ/COLLECT	INST. VOITURIER/DRIVER INSTRUCTIONS	VALEUR (\$2.00/lb max à moins d'avis contraire) VALUATION (Max \$2.00/lb unless otherwise stated) VALEUR DÉCLARÉE DE L'EXPÉDITION DECLARED VALUE OF SHIPMENT
EXPÉDITEUR/DISPATCHER			VOITURIER/DRIVER	REÇU PAR/RECEIVED BY

2. VOITURIER (CE CONNAISSEMENT DOIT ÊTRE SIGNÉ PAR L'EXPÉDITEUR ET LE VOITURIER)

Herstellerwerk / Manufacture's works / Usine productrice  ThyssenKrupp Niosta		Art der Prüfbescheinigung / Type of inspection document / Type du document ABNAHMEPRUEFZEUGNIS INSPECTION CERTIFICATE CERTIFICAT DE RECEPTION nach / according to / suivant EN 10204-3.1		Bescheinigungs-nr. / Document number / Numéro de document 1000186345 / Seite / Page / Page: 1 / 1							
35667 Dillenburg PF 1751 THYSSENKRUPP NIOSTA NORTH AMERICA INC. 2275 HALF DAY ROAD, SUITE 300 BANNOCKBURN, IL 60015 USA		Besteller/Empfänger / Customer/Consignee / Acheteur/Destataire THYSSENKRUPP NIOSTA, BANNOCKBURN, Kundenbestell-nr. / Customer's order number / Numéro de la commande du client 51001217 - PO C11584 Werksauftrag-nr. / Manufacturer's works order no. / N° de la commande de l'usine productrice 900382081 / 005 Lieferanzugs-Nr. / Delivery Note No. / Avis d'expédition N°. 87163835 / 010 Erzeugnis / Product / Produit BAND/COIL/ROULEAU									
Lieferbedingungen / Terms of delivery / Conditions de livraison ASTM A 240/A 240M ASME SA 240 Sec. II Part A Ed. 07		Stahlsorte und Gütegruppe / Steel grade and qual ity / Nuance de l'acier TYPE 304 L / 304									
Kundenmaterial-Nr. / Customer's material number / N° de matière du client Maße des Erzeugnisses (Dicke / Breite / Länge) / Product dimensions (Thickness / Width / Length) / Dimensions du produit (Epaisseur / Largeur / longueur) 0.0591 inch x 48.0000 inch		Hersteller / Steelmaking prod. / Mode d'élabor. AOD		Ausführung / Finish / Fini IIIc/2B							
Paket-Nr. / Packing-No. / N°-Paquet 5166172 5166173	Stückzahl / No of pieces / N° de pièces 1 1	Ist-Gewicht / Actual weight / Masse effective 20.470 lbs 20.624 lbs	Ident.-Nr. Erzeugnis / Ident.-No of product / Ident.-N° du produit 95913 95913	Schmelzennr. / Cast number / Id. de la coulée 854412 854412	Proben-Id. / Sample Id. / Echantillon prélevement 1002233268 1002233268						
2		41.094 lbs		1002233269 1002233269							
Chemische Zusammensetzung / Chemical composition / Composition chimique											
Schmelz-nr. / Cast no.	% C	% Si	% Mn	% P	% S	% Cr	% Ni	% N			
854412	0.022	0.40	1.21	0.030	0.0030	18.17	8.01	0.062			
Prüfling/Inspection lot / Lot de contrôle Proben-Id./-Lage / Sample Id./-Position Ident./Echantillon / Ident./Echantillon											
	YS0, 2%	YS1, 0	TS	EL.A2*	EV						
	PSI	PSI	PSI	PSI	PSI						
1002233268	43945	48876	94126	53.8	170						
1002233269	44960	50036	95431	53.7	170						
ASTM A 262 2a PRACTICE E I.O. Beständig gegen Interstit. Korros./Resistant to intercryst. corros./Résistant à la corros. intercryst.: Maße-Oberfläche/Dimensions-Surface/Dimensions-Surface: Verwechslungsprüfung (Spektralanalyse)/Test of Identity (spectrum analysis)/Contrôle d'identification (analyse spectrale): WAERMEBEHANDLUNG : 1050 GRAD C / LUFT TRAITEMENT TERMIQUE : 1050 GRAD C / AIR HEAT - TREATMENT : 1050 DEGREE / AIR FREE OF MERCURY AND RADIO ACTIVE CONTAMINATION No Ni of Cuban Origin, RoHS - Compliant NO WELD REPAIR											
Aussteller der Bescheinigung / Originator of the document / Auteur du document ThyssenKrupp Niosta GmbH Dieses Zeugnis wurde maschinell erstellt Werk Dillenburg Abnahme						Waffau Abnahmebeauftragter Inspector / Expert Tel: 02771-390301 Fax: 02771-390510		Stempel des (der) Abnahmebeauftragten Receiving expert's stamp Poliveau de l'agent réceptionnaire 		Datum der Ausstellung und Bestätigung Date of issue and validation date d'émission et validation 05.03.2010	

S
10/10/04

P102473
P102475